

Order ID 61881-2

y, September 08, 2010 3:27:17 PM



Page 1

Item ID: D4174-1

Revision ID: PRELIM

Item Name: Connector Plate

Start Date: 9/8/2010 Start Qty: 3.00

Required Date: 9/13/2010 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 10-9-08

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4174	PAI								
100		0.00							
Waterjet									
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev: PAI								
	Prog Rev: PAI								
	2-Deburr if necessary								
110		0.00							
QC									
Quality Control	Memo	0.00							

B10-9-13

(4)

B10-9-13

# Work Order ID 61881

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Page 2

Item ID: D4174-1

Accept

Revision ID: PRELIM

Item Name: Connector Plate

Start Date: 9/8/2010 Start Qty: 3.00

Required Date: 9/13/2010 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

-S1010413

QC

Memo

0.00

Inspector to PAI

Quality Control

Dry only

130

Chemical Conversion Coat per QSI005 4.1

0.00

BF 10-9-14.

HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BF 10-9-16

Powdercoat

Memo

0.00

Powder Coating

Start Time: 1:50  
Oven Temperature: 320°  
Finish Time: 2:20

# Work Order ID 61881

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Item ID: D4174-1  
Revision ID: PRELIM  
Item Name: Connector Plate

Accept



Setup Start



Stop



Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	=> M 10/09/10			X/	0		
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>composites</u>  Memo	0.00  0.00	1 - pulled					21 10-10-01	(K3)
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						10/10/04	(J)

POSITIVE RECALL  
EFFECTIVE 10/10/01 AUTH h  
RELEASED 10/10/01 DATE 10.10.01  
PER RELEASED DATA  
DATED 10.09.29

10/10/01  
(3)

# Picklist Print

Wednesday, September 08, 2010 3:27:21 PM

Page 1

Work Order ID: 61881

Parent Item: D4174-1

Parent Item Name: Connector Plate



Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

104.9340

0.11

0.347368

145



1810-9-13

6061 T6.063 Sheet

Location

Loc Qty

Loc Code

MAT21

104.934

113608

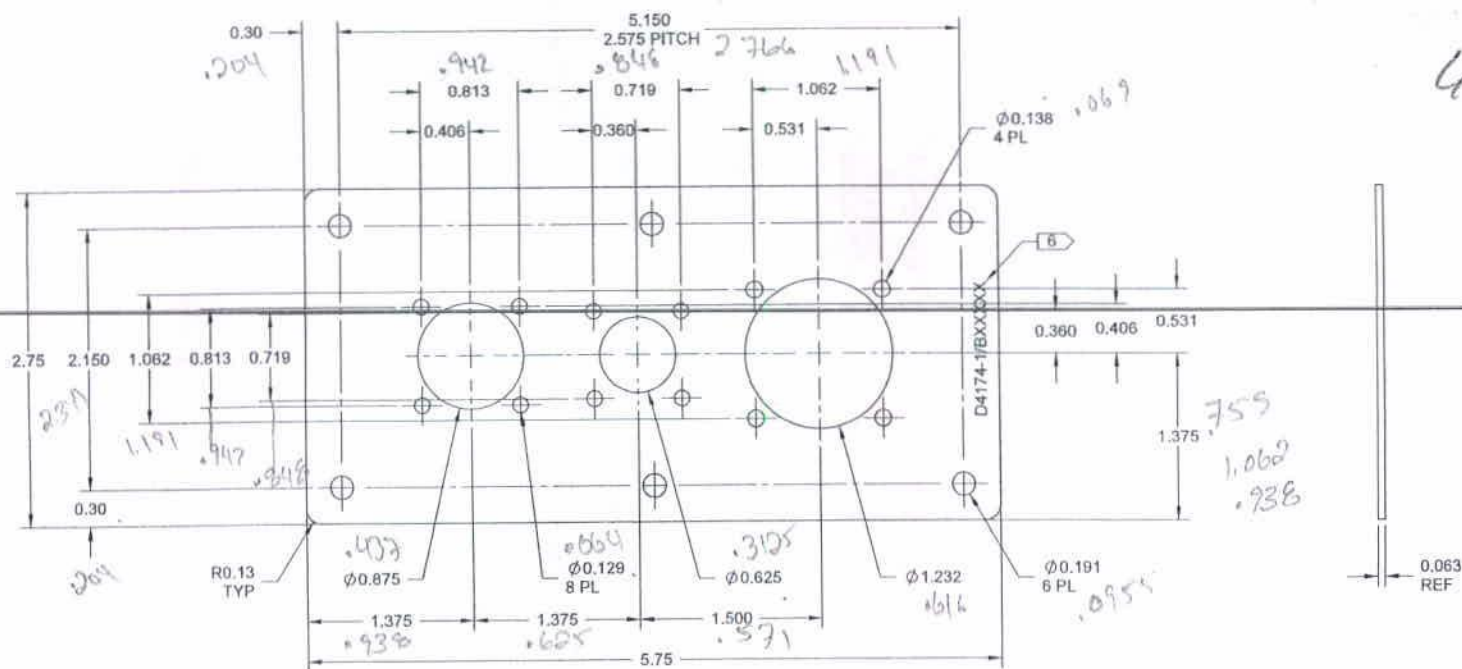
104.934

113608

④



LOVE



PRELIMINARY ISSUE

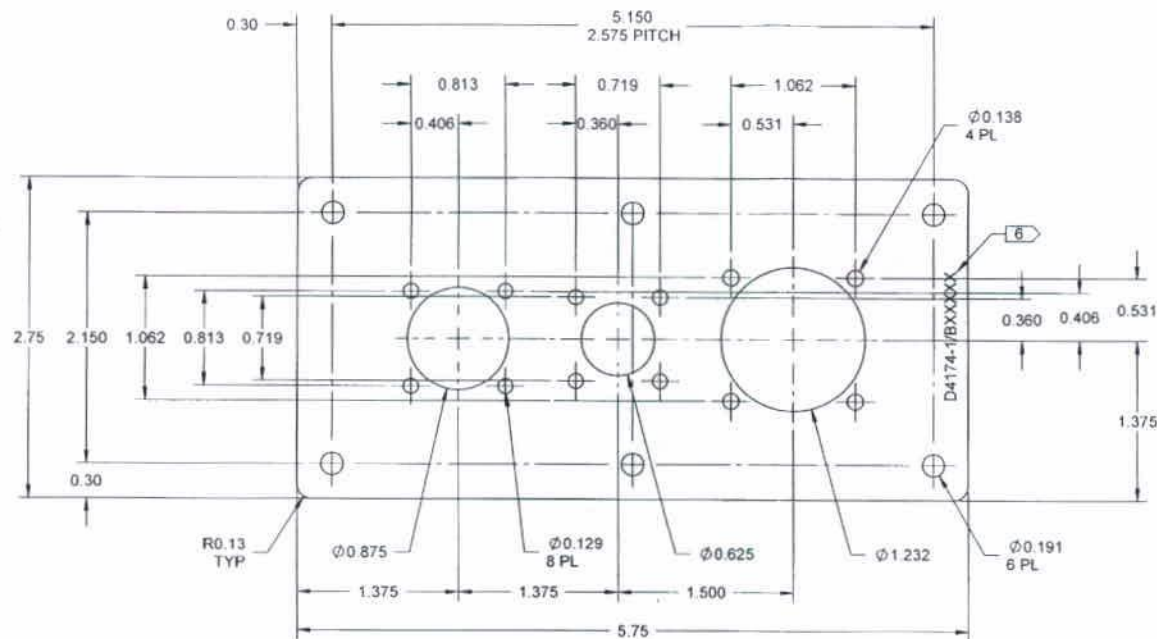
10.09.08

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.08 lbs

PA1	NEW ISSUE		MB	10.09.01
REV.		DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4174</b>  TITLE <b>CONNECTOR PLATE</b>  SCALE NTS  COPYRIGHT © 2016 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPRIETARY AND UNCLASSIFIED. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE ORDER. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	REV. PA1	
DRAWN			SHEET 1 OF 2	
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.09.01			





**D4174-1 CONNECTOR PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
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DESIGN	JL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.		D4174	SHEET 1 OF 2
APPROVED	JS	TITLE	SCALE
DE APPR.		CONNECTOR PLATE	NTS
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**RELEASED**  
2010-09-29

61881